



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBWST13045
Job Sheet 172635



Part No: RBWST13045

Job Qty: 1 ea *2*

Part Name: Nitrogen Tire Inflator



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBWST13045 Rev 3 IPP Rev A 18.02.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Small Fab-4		<i>MCC</i>
100	Small Fab	1 pcs		3/16/18	0.25	0.17	Small Fab-9		<i>MCC</i> <i>DAS</i>
110	QC	1 pcs		3/16/18	0.00	0.00	QC5		<i>38</i>
130	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-2 <i>GA</i>		<i>NAS</i> <i>APR 23 2018</i>
140	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		<i>APR 23 2018</i>

Part Op 100 - 1-Assemble as per DWG sheet 1 2-Orient -1 as shown
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
<i>#25 BOOT</i>	Boot Cover For 2 1/2" Gauge <i>RBWST13045-8 100</i>	1 (1 ea)	90-Start up Operation	<i>5036089</i>
4M3K	TBD <i>86</i>	1.5000 (1.5 ea)	90-Start up Operation	<i>5054667</i>
50695K162	Zinc Plated Fitting 1/4 NPT x 1/16-20 JIC <i>44</i>	1 Ea (1 ea)	90-Start up Operation	<i>5055039</i>
5232T243	Standard Tee 1/4 NPT <i>GA</i>	1 Ea (1 ea)	90-Start up Operation	<i>5048570 + 5055037</i>
5232T313	COUPLING 1/4 NPT TO 1/8 NPT <i>GA</i>	1 Ea (1 ea)	90-Start up Operation	<i>5055038</i>
5232T316	Hex Nipple 1/4 NPT TO 1/4 NPT <i>GA</i>	1 Ea (1 ea)	90-Start up Operation	<i>5055036</i>
5274T73	Polypropylene Vial <i>49</i>	1 Ea (1 ea)	90-Start up Operation	<i>5048575</i>
6050T14	Zinc Plated Fitting 1/4 NPTF x 1/4 Plug <i>GA</i>	1 Ea (1 ea)	90-Start up Operation	<i>5055040</i>
6852K11	Squeeze Grip Valve <i>48</i>	1 Ea (1 ea)	90-Start up Operation	<i>5048568 + 5055035</i>
8028	Schrader Valve <i>22</i>	1 (1 ea)	90-Start up Operation	<i>5061533</i>
8063K37	BRASS VALVE 1/4 NPT MALE x SCHRADER AIR VALVE <i>48</i>	1 Ea (1 ea)	90-Start up Operation	<i>5055041</i>
AMF556	Bleeder	1 Ea (1 ea)	90-Start up Operation	
<i>PFQ807</i>	TBD <i>RBWST13045-7 100</i>	1 (1 ea)	90-Start up Operation	<i>5054660 + 5036088</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	#25 BOOT	1	0	0
	4M3K	2	0	0
	50695K162	1	0	0
	5232T243	1	0	0
	5232T313	1	0	0
	5232T316	1	0	0
	5274T73	1	0	0
	6050T14	1	0	0
	6852K11	1	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Engineering ☐ Quality ☐ Other ☐																																																																																																																																								
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sitioned Wrong
 tside Dimensions
 er/Under tolerance
 t Incorrect
 : Lost/Missing
 Moved
 ving
 ...sh
 Misread
 Turning Sequence

8028	1	0	0
8063K37	1	0	0
AMF556	1	0	0
PFQ807	1	0	0

Part Specifications

Specifications could not be found.

Plex 2/21/18 8:43 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

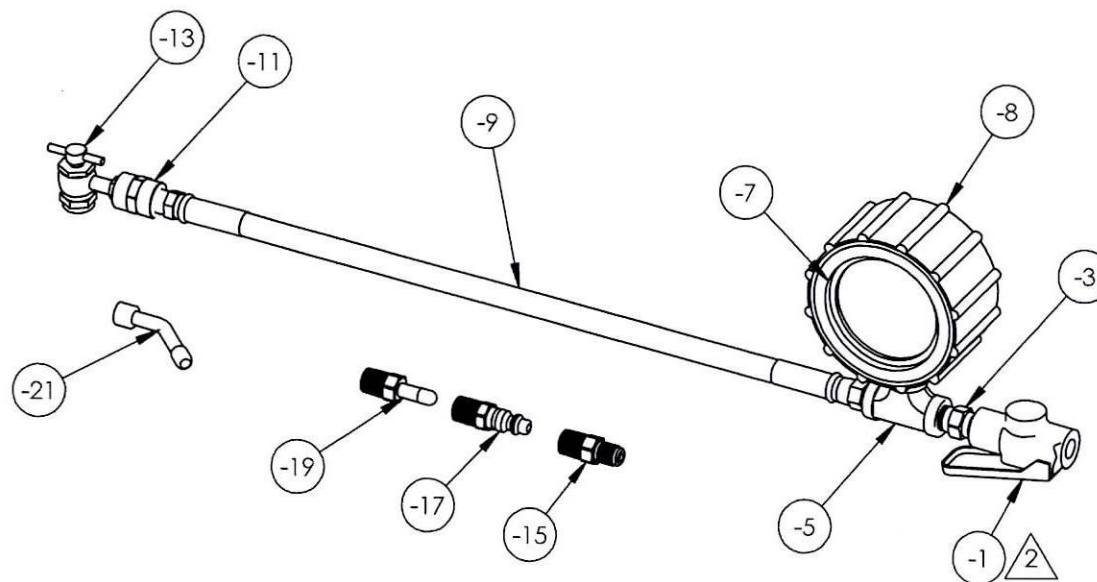
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 FLIPPED HANDLE VERTICAL, -9 UPDATED PART INFO, ADDED P/N -21 ADDED P/N.	1/4/2013	BIM	SE
B		CORRECTED ORIENTATION OF -1 TO FIT FOAM.	3/5/2014	JAG	GE
2	15-0299	-8 ADDED TO BOM, -19 MCMASTER-CARR #8063K38 NO LONGER AVAILABLE USE #8063K37.	9/14/2015	RJC	JAG
3	16-0100	UPDATED TO NEW STANDARD -7 CH'D B/O PART NUMBER WAS 2 1/2 PFG807CD IS 2-1/2 PFG807.	8/9/2016	DEW	SM



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172635 MJS
18-02-21

NOTE:
1. USED IN KIT RBW1205G00131-3G.
2. ORIENT -1 AS SHOW.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	-1	1	VALVE	ZINC ALLOY	(MCMASTER-CARR #6852K11)	1
		B/O	-3	1	HEX NIPPLE	ZINC-PLATED STEEL	1/4 NPT TO 1/4 NPT (MCMASTER-CARR #5232T316)	1
		B/O	-5	1	STANDARD TEE	ZINC-PLATED STEEL	1/4 NPT (MCMASTER-CARR #5232T243)	1
		B/O	-7	1	GAUGE		PARAMOUNT SUPPLY #2-1/2 PFG807	1
		B/O	-8	1	BOOT	RUBBER	PARAMOUNT SUPPLY #25	1
		B/O	-9	1	HOSE		PACIFIC RUBBER P/N 4M3K@ 18" OAL W/ MP& MPX (CRIMPED)	1
		B/O	-11	1	COUPLING	ZINC-PLATED STEEL	1/4 NPT TO 1/8 NPT (MCMASTER-CARR #5232T313)	1
		B/O	-13	1	BLEEDER	PLATED STEEL	PACIFIC RUBBER #AMF556	1
		B/O	-15	1	FITTING	ZINC-PLATED STEEL	1/4 NPT X 7/16-20 JIC (MCMASTER-CARR #50695K162)	1
		B/O	-17	1	FITTING	ZINC-PLATED STEEL	1/4 NPT X 1/4 PLUG (MCMASTER-CARR #6050T14)	1
		B/O	-19	1	VALVE	BRASS	1/4 NPT MALE X SCHRADER AIR VALVE (MCMASTER-CARR #8063K37)	1
		B/O	-21	1	VALVE		P/N 22596 SCHRADER 8028	1
		B/O	-23	1	VIAL	POLYPROPYLENE	(MCMASTER-CARR #5274T73)	NS

DART
AEROSPACE

TITLE
TIRE INFLATOR GAUGE, NITROGEN

DWG NO. RBWST13045

REV
3

MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER
SCALE 1:4	ASME Y14.5M-2009
DATE 12/19/2011	USED ON MODEL
	AW139
	SHEET 1 OF 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								